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D4093-3

Job Sheet 203042



Part No: D4093-3

Job Qty: 8 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/19

Job Tracking No:

Due Date: 12/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEETS 3,4 IPP REV:A NEW ISSUE 10-10-04 JLM VERIFIED BY:DD IPP REV:B AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD IPP REV:B AS PER REV C 11.09.28 JLM VERIFIED BY:DD IPP REV:C 12.10.31 AS PER DWG REV:C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	8 pcs		12/5/19	0.17	3.07	Waterjet - Flow <i>max</i>		<i>19/11/26</i>
130	Conventional Mill - 1 - B4B	8 pcs		12/5/19	0.25	1.60	Conventional Mill - 1 - B4B		<i>19/11/29</i>
							Conventional Mill - 2 - B4B		
135	QC 8	8 pcs		12/5/19	0.00	0.00	QC 8 - 12		<i>19-11-30</i>
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		

PRIORITY

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140 Handfinish - 1-1 Chemical-B4B	8 pcs	12/5/19	0.00 0.38	QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ DEC 02 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	8 pcs	12/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	DAS
				QC 7 - 81	81
				QC 7 - 76	9-89
				QC 7 - 79	
170 Packaging 3-1 - Stock - B4B	8 pcs	12/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	1.050Inches $\pm$ 0.030	1.080 1.020		
2	Bracket	3.850Inches $\pm$ 0.030	3.880 3.820		
3	Bracket	5.030Inches $\pm$ 0.030	5.060 5.000		
4	Bracket	0.380Inches $\pm$ 0.030	0.410 0.350		
5	Bracket	0.500Inches $\pm$ 0.030	0.530 0.470		
6	Bracket	4.820Inches $\pm$ 0.030	4.850 4.790		
7	Bracket	1.790Inches $\pm$ 0.030	1.820 1.760		
8	Bracket	0.380Inches $\pm$ 0.030	0.410 0.350		
9	Bracket	0.310Inches $\pm$ 0.030	0.340 0.280		
10	Bracket	4.200Inches $\pm$ 0.030	4.230 4.170		
11	Bracket	7.030Inches $\pm$ 0.030	7.060 7.000		
12	Bracket	0.750Inches $\pm$ 0.010	0.760 0.740		
13	Bracket	0.380Inches $\pm$ 0.030	0.410 0.350		
14	Bracket	1.130Inches $\pm$ 0.030	1.160 1.100		
15	Bracket	0.130Inches $\pm$ 0.030	0.160 0.100		
16	Bracket	1.130Inches $\pm$ 0.030	1.160 1.100		
17	Bracket	0.130Inches $\pm$ 0.030	0.160 0.100		
18	Bracket	0.080Inches + 0.004 - 0.001	0.084 0.079	Diameter	
19	Bracket	0.500Inches $\pm$ 0.010	0.510 0.490		
20	Bracket	1.500Inches $\pm$ 0.010	1.510 1.490		
21	Bracket	2.530Inches $\pm$ 0.010	2.540 2.520		
22	Bracket	1.500Inches $\pm$ 0.010	1.510 1.490		
23	Bracket	0.201Inches + 0.005 - 0.001	0.206 0.200	Diameter	
24	Bracket	2.390Inches $\pm$ 0.030	2.420 2.360		
25	Bracket	0.201Inches + 0.005 - 0.001	0.206 0.200	Diameter	
26	Bracket	0.370Inches $\pm$ 0.010	0.380 0.360	Countersink	
27	Bracket	100.000Degrees $\pm$ 0.500	100.500 99.500	Angle	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S235099



Part: D4093-3

Job No: 203042

Serial No/Batch: S235099

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 11/26/19